Work Order ID 70938

Monday, June 20, 2011 8:26:41 AM

Item ID: D206-642-341 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Replacement Skidtube

Start Date: 6/20/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 7/8/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** 11-06-20 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D2650 / F									
100	DOCUMENT CONTROL	0.00				N/A			
DC		0.00							
Document Control	**Memo** Photocopy bluefile and create labels per PPP D206-642-341 CHG003								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650 } DL. 11/06/20

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.
A/R□□Aluminum Rod□ M117456/M112869 , BE 11/06/20

4-Grind weld flush to cap on top surface only. BE 11/06/20

5-Cut aft end to lenght as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

BB 11/06/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
125	QC3- Inspect Part Finish	0.00				1	0		
QC	Memo	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Skidtubes	Skidtubes								
	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) 2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid) 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. 4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting☐ Start Date: 3:50 ☐Time:☐ 11/06/28 Finish Date: 11/06/29 ☐Time:☐ 11:00 A/R☐☐Sikaflex-291☐ M116945☐ Sikaflex expiry date:☐ 12/01/15					1			BB 11/06/28 DL 11/06/28
140	QC5- Inspect part completeness to step on W/O	0.00							
QC									
	Memo	0.00							
Quality Control						1	D		BE 11/06/29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty.	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							
	1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. A/R□□Aluminum Rod□ M112860 BE 11/06/29								
	2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube JB 11/07/04								
	3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr BE 11/07/04								
	4- Install nut plate as per dwg JB 11/07/04								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	**Memo**	0.00 D 11/07/04							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

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Required Date: 7/8/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
190	Pressure Wash per QSI005 4.3	0.00							
HandFinish	**Memo**	0.00							
Hand Finishing	Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.								
205		0.00							
SprayPaint	**Memo**	0.00							
Spray Painting	PRIME B 117319 DELFLEET BLUE B 115985 DELFLEET CLEAR B 117113								

Dart Aerospace Ltd

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Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
215	QC14- Inspect Spray Paint	0.00							
QC	Memo	0.00							
Quality Control									

11 07 13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Item Name: Replacement Skidtube **Stop**

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Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
HandFinish	HandFinishing					1	ϕ		11/07/14
Hand Finishing	**Memo**	0.00							

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.
A/R□□Sikaflex-291□ M116040□□
Sikaflex expiry date:□ 15/01

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive
A/R□□Sikaflex-291□ M116040□
Sikaflex expiry date:□ 15/01

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4□
Batch: M117863

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									
240	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
250	Packaging	0.00							
Packaging	**Memo**	0.00							
Packaging									

Identify and pack for shipping as per PPP D206-642-341

Location: PAP69658

PPP Rev:

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Run **Start**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/7/14

MF 11-07-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Monday, June 20, 2011 8:26:48 AM

Work Order ID: 70938

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011 **Required Date:** 7/8/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM
IPP Rev:I 08-09-29 revF as per dwg DD verified by:EC Est Rev:J 09-03-02 as per DSI9440 rev.a DD verified by:EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD416	NAS1149D0463J	Purchased	No				Each	0.0000		1			
Washer							M117591			(x1)	M	11/07/14	
CCR264SS3-3		Purchased	No				Each	569.0000		2			
Cherry Rivet										2		B 11/07/04	

Location	Loc Qty	Loc Code
FP-B	2	
113973	2	
ST311	567	
117086	71	
117849	496	

CR3212-4-03		Purchased	No				Each	1,216.000		2			
Cherry Rivet										2		B 11/07/04	

Location	Loc Qty	Loc Code
FP-B	2	
110139	2	
ST311	1214	
114859	1214	

Dart Aerospace Ltd

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Work Order ID: 70938

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011 **Required Date:** 7/8/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2620 Manufactured No Each 12.0000 1

Skidtube, 206 Skidtube

11/06/20

Location	Loc Qty	Loc Code
LG	12	
62684	1	
68135	1	
68136	10	

D2647 Manufactured No Each 25.0000 1

Cap

BE 11/06/20

Location	Loc Qty	Loc Code
LG002	25	
55352	25	

D2649 Manufactured No Each 111.0000 19

Cross Bolt Spacer

BE 11/06/29

~~70394~~ 19

Location	Loc Qty	Loc Code
LG	99	
68224	2	
70394	97	19
LG001	12	
65317	1	
68507	11	

D2654-5 Manufactured No Each 3.0000 1

Web

11/06/20

Location	Loc Qty	Loc Code
LG	3	
70229	3	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Monday, June 20, 2011 8:26:48 AM

Work Order ID: 70938

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011 **Required Date:** 7/8/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2680-041 Manufactured No Each 30.0000 1

Nut Plate

Location		Loc Qty	Loc Code
ST020		30	
	55366	17	
	70088	13	

11/07/04

MS27039C1-08 Purchased No Each 804.0000 56

SCREW

Location		Loc Qty	Loc Code
FP-A		1	
	116022	1	
ST293		803	
	116373	3	
	117291	800	X56

11/07/14

ALS4-1032-130 Purchased No 220 Each 1,498.000 54 54

Insert

Location		Loc Qty	Loc Code
ST281		8	
	117331	8	
ST282		1490	
	117717	1490	X54

11/07/14

AN960C10L NAS1149C0332R Purchased No 220 Each 0.0000 54 54

M118306

(X54) 11/07/14

washer

AN960JD10L NAS1149D0332J Purchased No 220 Each 0.0000 2 2

M117087

(X2) 11/07/14

Washer

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Monday, June 20, 2011 8:26:49 AM

Work Order ID: 70938

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011 **Required Date:** 7/8/2011

Start Qty: 1.00 **Required Qty:** 1.00

D2646	Manufactured	No	220	Each	82.0000	1	1	
Aft Cap								M 11/07/14

Location		Loc Qty	Loc Code	
FP004		62	B71038	
	68280	62		X1
FP006		20		
	62678	20		

D2651-1	Manufactured	No	220	Each	251.0000	14	14	
Plug								M 11/07/14

Location		Loc Qty	Loc Code	
fpa		109		
	69018	109		
FP-A		142	B70942	x 14
	57869	1		
	66445	10		
	67760	97		
	70827	30		
	70839	4		

D2651-3	Manufactured	No	220	Each	536.0000	14	14	
O-Ring								M 11/09/14

Location		Loc Qty	Loc Code	
FP-A		536		
	61962	104		x 14
	66956	432		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 8:26:49 AM

Work Order ID: 70938

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011 **Required Date:** 7/8/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3535-11	Manufactured	No	220	Each	8.0000	1	1	
Wearshoe								

Location	Loc Qty	Loc Code	
FP019	8		
68362	8		

D3535-23	Manufactured	No	220	Each	20.0000	1	1	
Wearshoe								

Location	Loc Qty	Loc Code	
FP021	20		
66236	-1		
67594	8		
68342	13		

D3535-35	Manufactured	No	220	Each	30.0000	1	1	
Wearshoe								

Location	Loc Qty	Loc Code	
FP018	10		
65926	1		
67598	1		
68348	8		
ST	20		
69756	20		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 20, 2011 8:26:49 AM

Work Order ID: 70938

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011 **Required Date:** 7/8/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3536-11	Manufactured	No	220	Each	13.0000	1	1	
Gasket								M 11/07/14

Location	Loc Qty	Loc Code	
FP011	13		X1
46649	1	B71283	
46715	4		
65574	8		

D3536-23	Manufactured	No	220	Each	39.0000	1	1	
Gasket								M 11/07/14

Location	Loc Qty	Loc Code	
FP011	39		
43406	1		
66560	12		
69902	26		X1

D3536-35	Manufactured	No	220	Each	27.0000	1	1	
Gasket								M 11/07/14

Location	Loc Qty	Loc Code	
FP012	27		
67599	1		
69755	26		X1

D3537-1	Manufactured	No	220	Each	10.0000	6	6	
Wearpad								M 11/07/14

Location	Loc Qty	Loc Code	
FP017	10	B70686	X6
69817	10		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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Picklist Print

Monday, June 20, 2011 8:26:49 AM

Work Order ID: 70938

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 6/20/2011 **Required Date:** 7/8/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3537-3 Wearpad	Manufactured	No	220	Each	9.0000	1	1	JL 4/07/14

Location		Loc Qty	Loc Code	
FP017		1	B70817	
	35697	1		VI
FP19		8		
	69292	8		

MS27039-4-06 Screw	Purchased	No	220	Each	57.0000	1	1	JL 4/07/14

Location		Loc Qty	Loc Code	
FP-A		23		
	115460	23		XI
ST292		34		
	115460	34		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				**D2650-1**	**SKIDTUBE ASSEMBLY**
	X			**D2650-3**	**SKIDTUBE ASSEMBLY**
		X		**D2650-5**	**SKIDTUBE ASSEMBLY**
			X	**D2650-7**	**SKIDTUBE ASSEMBLY**
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

F

NOTES:

1) MATERIAL: N/A
2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   -POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
   -BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: N/A
8) WELD PER DART QSI 004
9) DAMAGE TOLERANCE ON FWD BEND:
   THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70938
11-06-20

RELEASED
08.09.23

REV.	DESCRIPTION	BY	DATE
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCORP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25

DESIGN	DS	**DART AEROSPACE USA, INC** PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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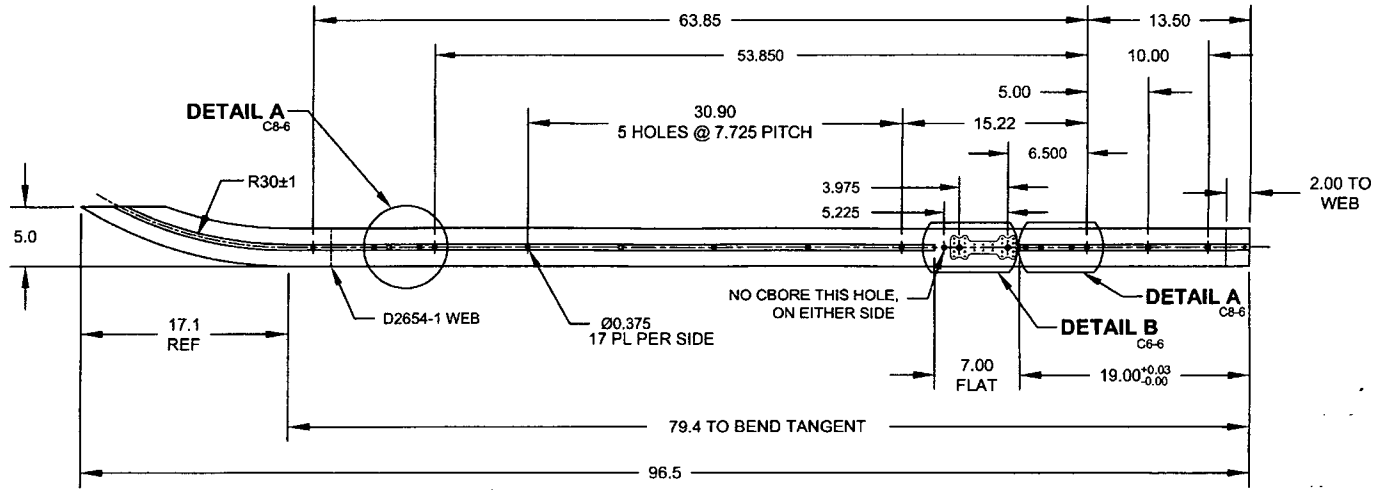
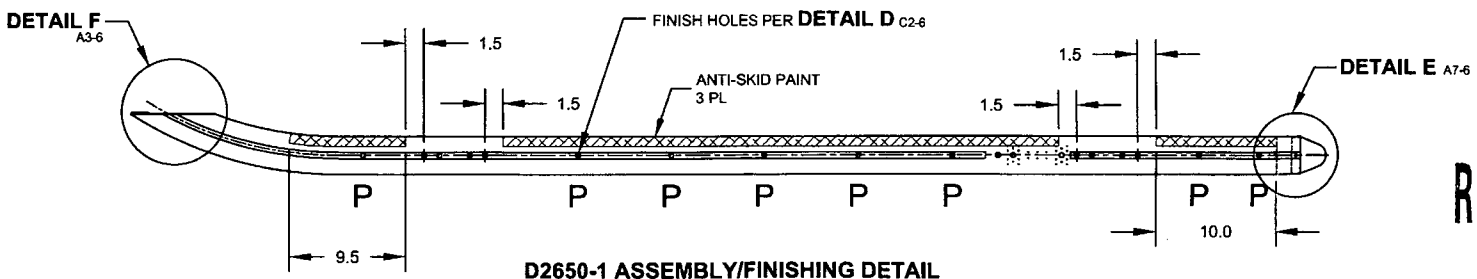
NOTE: Date & initial all entries



D2650-1 BENDING/DRILLING DETAIL

w/o 70938



D2650-1 ASSEMBLY/FINISHING DETAIL

RELEASED 08-09-22

DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. F
MFG. APPR.		D2650 SHEET 2 OF 6
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DE APPR.		206/407 SKIDTUBE ASSEMBLIES NTS
DATE	08.08.08	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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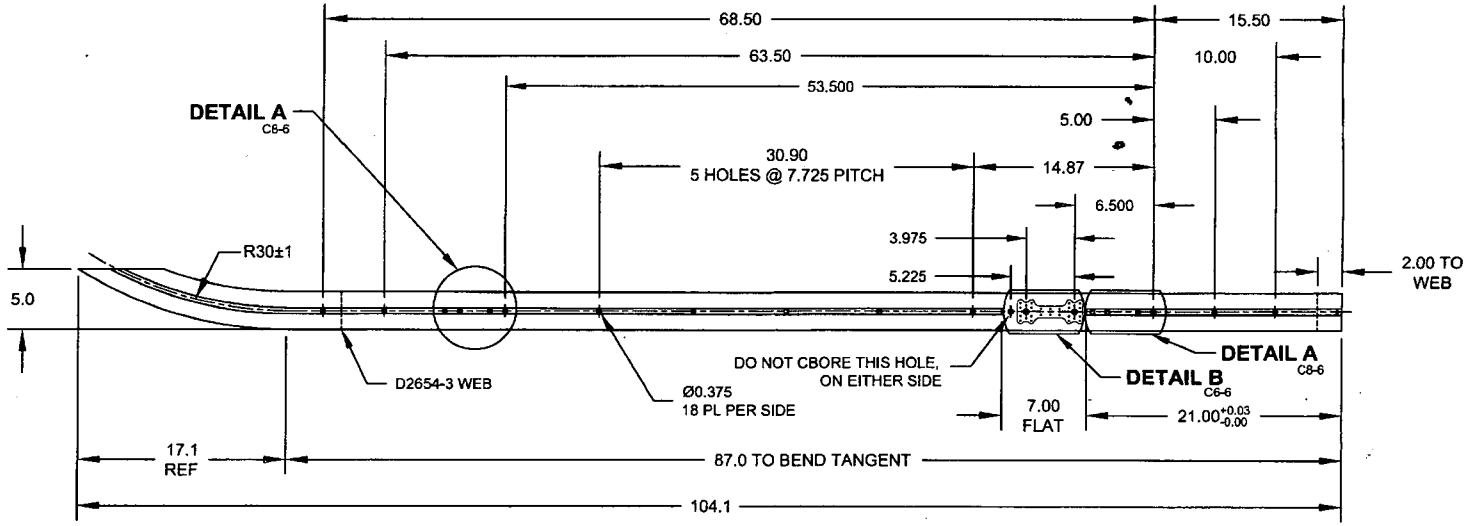
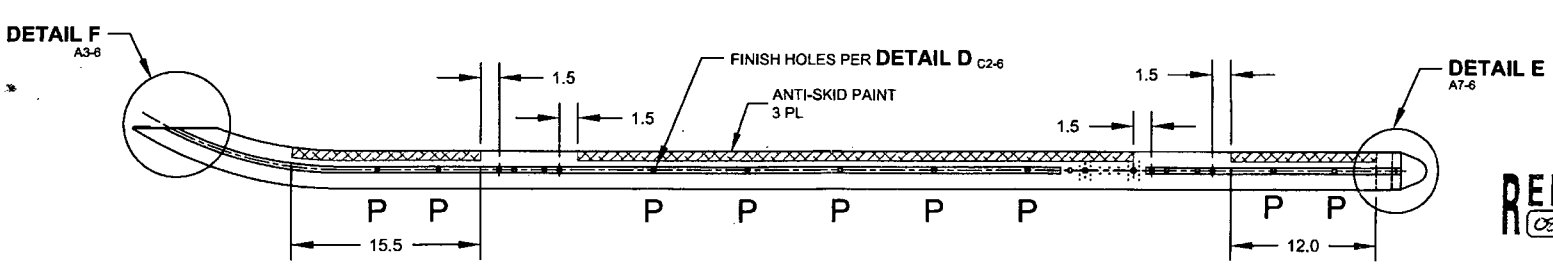


D2650-3 BENDING/DRILLING DETAIL

W/070938



D2650-3 ASSEMBLY/FINISHING DETAIL

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DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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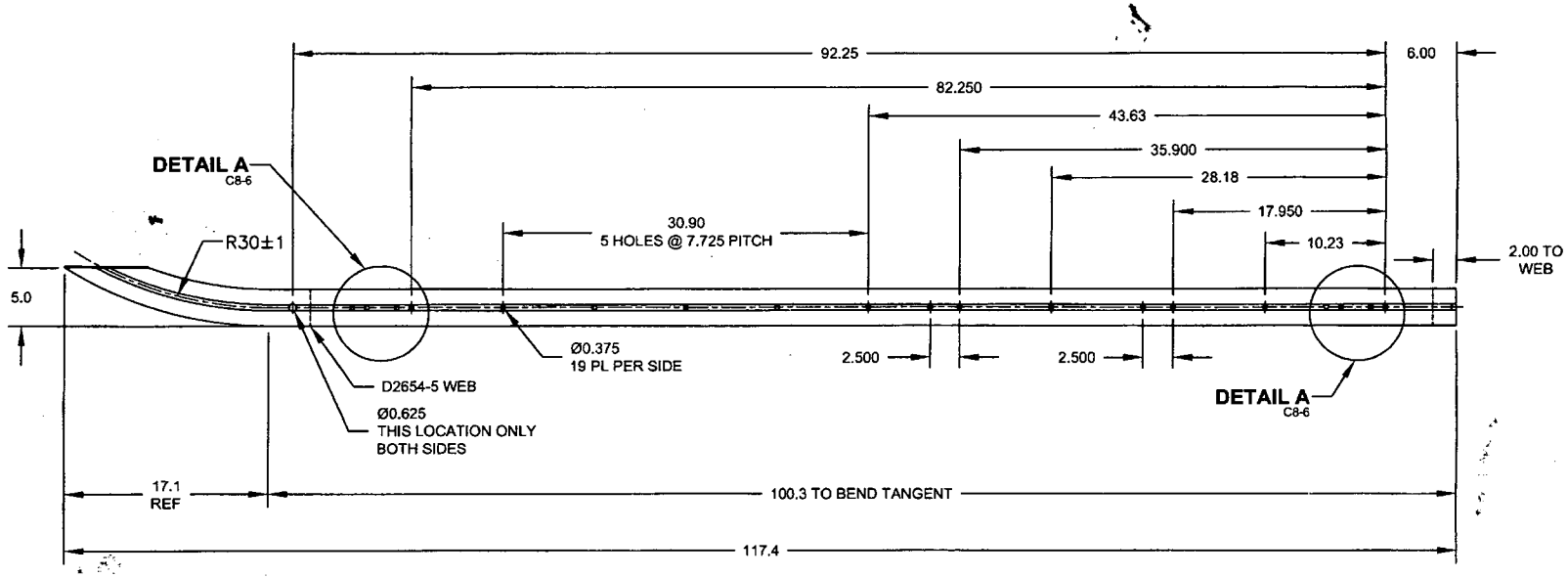
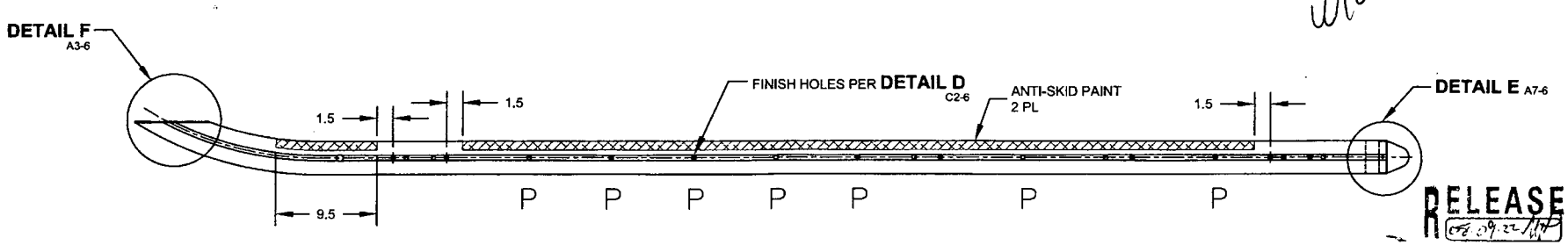


D2650-5 BENDING/DRILLING DETAIL

w/o 70938



RELEASED

D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. F
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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

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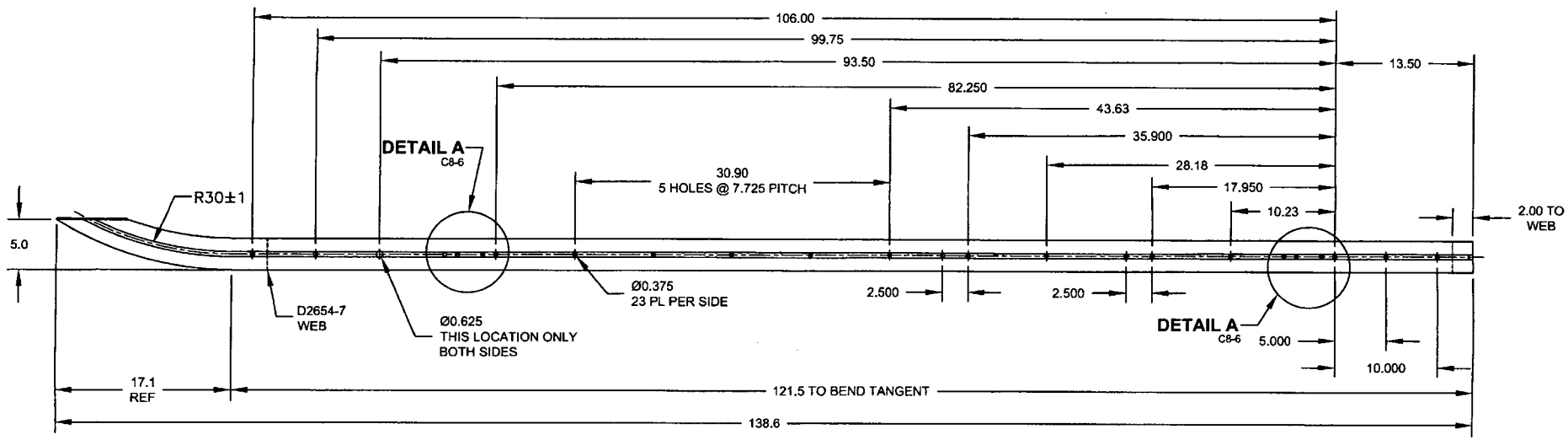
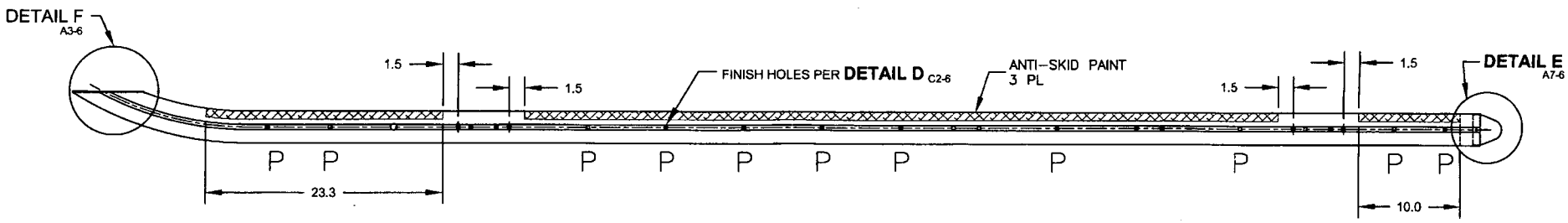


D2650-7 BENDING/DRILL DETAIL

w/o 70938

RELEASED
07.22



D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN	AJS	
CHECKED		DRAWING NO. D2650 — REV. F — SHEET 5 OF 6
MFG. APPR.		
APPROVED		TITLE: 206/407 SKIDTUBE ASSEMBLIES — SCALE: NTS
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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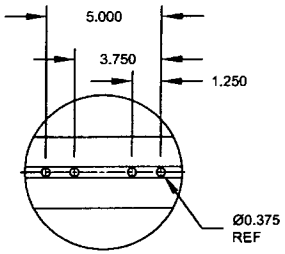
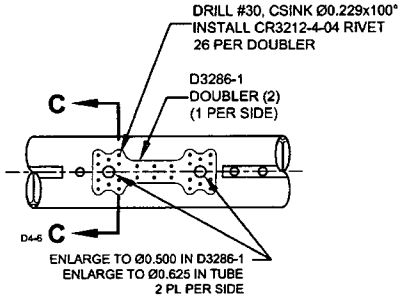
NOTE: Date & initial all entries

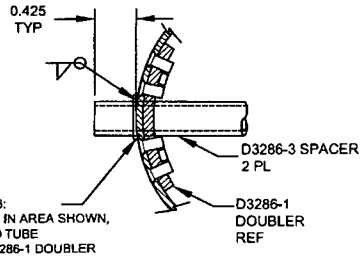


DETAIL A C2-2 D7-2 C2-3 D7-3 C2-4 D7-4 C2-5 D6-5
SCALE 2X

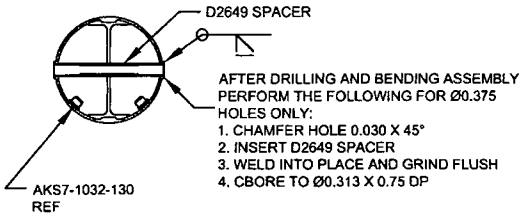


DETAIL B C3-2 C3-3
SCALE 2X

SECTION C-C C7-6
SCALE NONE

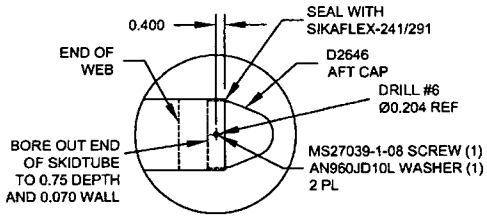


TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO Ø0.500
4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE. (F)

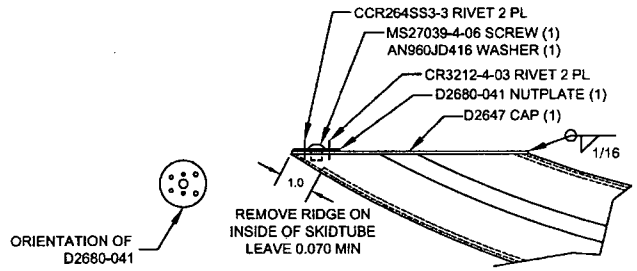


DETAIL D B4-2 B4-3 B4-4 B4-5
FOR Ø0.375 HOLES ONLY
SCALE 3X

w/o 70938



DETAIL E B2-2 B2-3 B1-4 B1-5
SCALE 2X



DETAIL F B8-2 B8-3 B8-4 B8-5
SCALE NONE

DETAIL F NOTES:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED 08-09-22

DESIGN	DS	**DART AEROSPACE USA, INC** PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08		

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W/O:		WORK ORDER CHANGES					
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

NO. ~~255~~ 255

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barklay Elliot
Job number: ~~69958~~ 69953
Part number: 5206-642-341
Description: 206
Welding Process: Tig[X] Mig[ ]
Base materiel:
Current: AC[X] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓]	fail[ ]
Penetration:	pass[✓]	fail[ ]

UNACCEPTABLE

Cracks:	pass[✓]	fail[ ]
Undercut:	pass[✓]	fail[ ]
Pin holes:	pass[✓]	fail[ ]
Overlap (cold lap)	pass[✓]	fail[ ]
Porosity (surface):	pass[✓]	fail[ ]
Coloration:	pass[✓]	fail[ ]

Qualifier Pat Lewis **Date of Test Coupon** 11·06·14

Welder Barclay Elliot **Date of Test Coupon** 11/06/14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld